April-18-13 10:28:16 AM

646.3913

QC: _____ Date: ____ SPC (Y/N):

Item ID: 646.3913

Required Date: 5/02/13

E100136

" Can of

Accept

N900040100

Date: _____

Tool # Plan

Code

Setup Start

Item Name: Start Date:

Revision ID:

Shim

4/18/13

Start Qty: 20.00 Req'd Qty: 20.00

20 *20*

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: ML5 Date: 13-04-18 Tooling:

Date:

Run

Reject

Qty

Stop

Reject

Number Stamp

Insp.

Sequence ID/ Operation Work Center ID Description Draw Nbr **Revision Nbr** 646.3900 N/C 110

110

Waterjet

Memo

0.00

0.00

Set Up/

Run Hours

200

Accept

Qty

FLOW CNC Waterjet

MC10955.032 Blue Spring Steel

1-Cut as per Dwg Dwg Rev: N/C

Prog Rev: N/C

2-Deburr if necessary

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

0.00

20 0

JM13-07-02

Quality Control

Memo

											DQA:	Date:	- 6
NCR:	es .	/ No				WORK ORDER NON-C	O	NFORN	MANCE / UPDA		QA Closed:	Date:	
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NCR I	vo		<u> </u>		 	Work Order Opdate	,		Large Fab	omposite		Supplier	لــا لـ
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		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Uncl	lear	Part Lost/M	issing	Wrong Stock Pulled
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	\square	Heat Trea	it			Countersink		Mislabe	eled		Positioned \	N rong	
		nspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss,	/Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Packaging

April-18-13 10:28:16.4M Item ID: 646.3913 Accept *N900040100* Setup Start *NS1* **Revision ID:** Item Name: Shim Start Date: 4/18/13 **Start Qty: 20.00 Cust Item ID:** Required Date: 5/02/13 Req'd Qty: 20.00 **Customer:** Reference: Run Process Plan: _____ Date: ____ Tooling: Approvals: Date: QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID **Description Run Hours** Code Qty Qty Number Stamp 130 QC8- Inspect parts - second check 0.00 *130* QC Memo Quality Control 140 Outsource process-Cadplate per QSI017 4.1.9.1 0.00 CX 13/07/04 20 Outsource3 0.00 Memo Issue P/O: 20424 Outsource process - Cad plate 150 Receive & Inspect for Damage & Mat'l Certs /43/1/26 (2e) 0.00 *150* Packaging Memo 0.00

											DQA:	Date:	.
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											QA Closed:	Date:	
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Work Ord	er:	nii Wi				Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part I	No.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raiti	١٠.					Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
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	1	Inspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Packaging

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND

180

Quality Control

Memo

MLJ 13-07-30 MLJ 13-07-29

Insp.

Stamp

180

QC21- Final Inspection - Work Order Release

0.00

0.00

												DQA:	Dat	.e:	v
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORI	MANCE / UP	DATE		_	_		
<u> </u>	24								all and the second second		С	(A Closed:	Dat	:e:	
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		Heat Trea	at			Countersink		Mislabe	led		Ţ	Positioned V	Vrong		
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Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Order ID: 100136

Parent Item:

646.3913

Parent Item Name: Shim

100136 *646 3913*

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A 12.10.23 NEW ISSUE DD VERF:

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
	MC1095S.032		Purchased	No			110	sf	9.5000	0.02	0.421053		,		
er Se	*MC1095S C1095 Blue Tempered Spring									**	0.5		J	mB-07-0	25

C1095 Blue Tempered Spring Steel Sheet .032

Location Loc Oty Loc Code MAT022 9.5 123537 123537 9.5

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										QA Closed:	Dat	:e:	
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Part N	lo				Scrap	1 1		Machining Small Fal	-	Prod	d. Eng. Coor.		Quality
, are r					Use-as-is	1		noforming Finishing			e/Packaging		Other
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Root					ption of work order update	1	nitial	Action		Sign &			
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	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re	_	Over/Under		-	Temperature/Cure
	Cracks				Broken/Damaged	Ш	Inspect	on Incomplete		Part Incorre		\vdash	Weld
	Crushed	I/Crimped	l.		Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	100136
Description: Shim	Part Number:	646.3913
Inspection Dwg: 646.3900 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.005	1.005"			υ	Themos
2.90	+/-0.005	2.895"			0	
0.032	+/-0.005	1.005° 2.895° 0.030°			U	
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Measured by: Jm	Audited by:	Preliminary Approval:	
Date: (3-0	Date: 3/9/0	Date:	*

Rev	Date	Change	Revised by A	Approved
Α	12.11.30	New Issue	KJ GKI	<i>(</i>
·				·

Packing Slip



Sold To:

Dart Aerospace Ltd. 1270 Aberdeen St.

Hawksbury, ON K6A 1K7

ShipTo:

Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2 **Phone:** (204) 633-9420 **Fax:** (204) 633-8033

INVOICE NUMBER:

S66940

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Cust	omer Ore PO20424	der #: DateReceive	NET 30 DAYS 10071 6547 RT0001 Jul-25-2013	
Item #	Qty I	P/N & Description	PLANT TO THE PARTY OF THE PARTY	
1	20 EA	SHIM	S/N: 100135 : 1 3 3 4 4 4	
	P/N	646.3910	W/O 126435	
2	20 EA	SHIM	S/NE 998410 FLA (1946 V)	*
	P/N	646.3912	W/O 126436 #PA A PA 45412	
3	30 EA	SHIM	S/NV 100136 % % NV 100136 % NV 100136 % % NV 100136 % NV 100136 % % NV 100136	-
1	P/N	646.3913	W/O 126437	

GERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE WINNIPEG, MANITOBA R2J-0J1

DATE:

Jul-25-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

126437

INVOICE #:

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66940

CONTRACT OR

PURCHASE ORDER #

PO20424

DESCRIPTION: SHIM

P/N# 646.3913

S/N # 100136

STRIP IAW MIL-STD-871. CADMIUM PLATING IAW AMS-QQ-P-416Ca71. Cadda and the state of TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART #113-644 AND # 113-1888 2. The BERT HEAT 649.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector: